

TABLE OF CONTENTS

1.0	DIESEL GENERATORS AS EMERGENCY POWER SOURCES	1-1
1.1	Regulatory Basis for Redundant, Independent Power Systems	1-1
1.2	RG 1.9 Sets the 3 Fundamental Performance Requirements for EDGs..	1-2
1.3	Why DIESEL Generators?.....	1-3
1.4	An Overview of EDG Regulations, Guides, Codes, and Standards.....	1-4
1.4.1	Early Plants Licensed under AEC General Design Criteria	1-4
1.4.2	Plants Licensed by NRC Using the GDC of 10CFR50 Appendix A	1-5
1.4.3	"Top Level" NRC Regulations that Pertain to NPP	1-5
1.5	Implementation of These Criteria into Site-Specific System Design	1-7
1.5.1	Overview of Primary Regulatory	1-7
1.5.2	Licensee's Implementation of EDG System Design Criteria.....	1-9
1.5.3	EDG Component Selection	1-11
2.0	INTRODUCTION TO DIESEL ENGINES	2-1
2.1	Introduction to Emergency Diesel Generators.....	2-1
2.2	Energy Conversion	2-1
2.2.1	Combustion	2-1
2.2.2	Cylinder Activity	2-2
2.2.3	Four-Stroke Cycle Operation.....	2-3
2.2.4	Two-Stroke Cycle Operation - Conventional	2-5
2.2.5	Two-Stroke Cycle Operation - Opposed Piston.....	2-6
2.2.6	Two-Stroke vs Four-Stroke Cycles	2-7
2.2.7	Typical Times for All Events	2-8
2.3	Diesel Engine Terminology.....	2-8
2.3.1	Dimensional Specifications.....	2-8
2.3.2	Engine Performance.....	2-10
2.3.3	Engine Efficiency.....	2-11
2.3.4	Additional Terminology	2-12
2.4	Typical Engine Design Criteria	2-13
2.5	Chapter Summary	2-13
3.0	DIESEL ENGINE CONSTRUCTION	3-1
3.1	Structural Components.....	3-1
3.1.1	Structural Loading	3-1

TABLE OF CONTENTS

3.1.2	Engine Block	3-2
3.1.3	Engine Cylinders	3-2
3.2	Engine Bearings	3-3
3.2.1	Journal Bearings.....	3-3
3.2.2	Rolling Element Bearings	3-3
3.3	Rotating and Reciprocating Components.....	3-3
3.3.1	Pistons.....	3-3
3.3.2	Piston Rings	3-4
3.3.3	Piston Pins	3-6
3.3.4	Connecting Rods.....	3-6
3.3.5	Crankshaft.....	3-7
3.3.6	Flywheel and Vibration Damper.....	3-7
3.4	Cylinder Heads	3-8
3.4.1	Cylinder Head Construction.....	3-9
3.4.2	Valves and Valve Seats.....	3-9
3.4.3	Valve Guides	3-9
3.4.4	Valve Springs and Retainers	3-9
3.5	Camshafts and Valve Mechanisms	3-9
3.5.1	Cams	3-10
3.5.2	Cam Followers.....	3-10
3.5.3	Camshaft Drive Mechanism	3-10
3.5.4	Rocker Arms and Pushrods.....	3-10
4.0	FUEL, AIR, AND ENGINE GOVERNING	4-1
4.1	Introduction to the Air and Fuel Systems.....	4-1
4.1.1	Air and Fuel for Combustion.....	4-1
4.1.2	The Combustion Process	4-2
4.1.3	The Combustion Process	4-3
4.2	The Intake Air System	4-3
4.2.1	Intake Air System Requirements	4-3
4.2.2	The Typical Intake Air System	4-4
4.2.3	Blowers and Turbochargers	4-5
4.3	The Exhaust System	4-7
4.3.1	Exhaust System Requirements	4-7
4.3.2	Exhaust System Components	4-7
4.4	The Diesel Engine Fuel System	4-8
4.4.1	Fuel System Functions	4-8
4.4.2	Fuel Oil Storage and Transfer System	4-9
4.4.3	Fuel Oil Supply System	4-10

TABLE OF CONTENTS

4.5	Fuel Injection Systems	4-10
4.5.1	Fuel Injection Pump and Nozzle System	4-11
4.5.2	Fuel Injection Nozzles	4-12
4.5.3	Injection Nozzle Operation	4-13
4.5.4	Unit Type Fuel Injectors.....	4-13
4.5.5	Injector Operation	4-14
4.6	Introduction to Governors	4-15
4.6.1	Governor Functions.....	4-15
4.6.2	Nuclear Application Governors	4-16
5.0	ENGINE LUBRICATION SYSTEM	5-1
5.1	Lubrication Fundamentals	5-1
5.1.1	Friction.....	5-1
5.1.2	Lubrication.....	5-2
5.1.3	Lubricants.....	5-2
5.2	Lubrication Systems	5-4
5.2.1	Lube Oil Sump.....	5-4
5.2.2	Lube Oil Pump.....	5-4
5.2.3	Lube Oil Strainers.....	5-4
5.2.4	Lube Oil Filters	5-5
5.2.5	Lube Oil Cooler.....	5-5
5.2.6	Lube Oil Header	5-5
5.2.7	Pressure Relief Valve	5-6
5.2.8	Pressure Regulating Valve	5-6
5.2.9	Engine Prelube/Keep Warm System	5-6
5.3	Crankcase Vacuum	5-6
6.0	ENGINE COOLING SYSTEMS	6-1
6.1	Engine Cooling	6-1
6.1.1	Cooling System Basics.....	6-1
6.1.2	Engine Cooling Systems	6-2
6.1.3	Jacket Water Keep Warm Systems	6-4
6.2	Intercooler Water System	6-5
6.3	Other Cooling Requirements	6-5
7.0	DIESEL ENGINE STARTING SYSTEMS	7-1

TABLE OF CONTENTS

7.1	Technical Specification Starting Requirements	7-1
7.2	Starting Characteristics	7-1
7.2.1	Admission of Air.....	7-1
7.2.2	Compression of Air Charge	7-2
7.2.3	Injection of Fuel	7-2
7.2.4	Compression Characteristics.....	7-2
7.3	Starting System Capability	7-2
7.3.1	System Capability.....	7-2
7.3.2	System Redundancy	7-3
7.3.3	Energy Storage System.....	7-3
7.4	Starting Air Systems	7-3
7.4.1	Direct Air Injection Systems.....	7-3
7.4.2	Starting Air Motor System.....	7-7
7.4.3	Supplemental Components	7-8
7.4.4	Starting Air Supply Systems	7-9
7.4.5	Control Air	7-11
7.5	Electric Starting Systems.....	7-11
7.5.1	Electric Starting Motor	7-11
7.5.2	Batteries	7-12
8.0	DIESEL ENGINE CONTROLS AND GOVERNING	8-1
8.1	Control Fundamentals	8-1
8.1.1	Diesel Engine to Generator Relationship.....	8-1
8.1.2	Governor Principles	8-1
8.1.3	Governor Classification	8-4
8.1.4	Principles of Operation	8-4
8.1.5	Nuclear Application Governors	8-7
8.2	Engine Control Governor Operation	8-8
8.2.1	Woodward EG Governor/Actuator	8-9
8.2.2	EG-A Control Box	8-14
8.3	The 2301A Governing System.....	8-15
8.3.1	2301A Actuator.....	8-15
8.3.2	2301A Control Box	8-16
8.3.3	Speed Reference Input.....	8-16
8.4	Governor System Change Out	8-17

TABLE OF CONTENTS

8.4.1	Advantages and Disadvantages	8-17
8.4.2	Fast Start Problem.....	8-18
8.4.3	Governor Conversions	8-18
8.5	Other Possible Governor Systems	8-18
8.6	Governor-Linkage Relationship	8-20
8.7	Engine Overspeed Governor/Trip.....	8-20
9.0	GENERATOR, EXCITER, AND VOLTAGE REGULATION.....	9-1
9.1	Generator Principles.....	9-1
9.1.1	Electromagnetic Induction	9-1
9.1.2	Induced Voltage.....	9-1
9.1.3	How the Generator Works	9-2
9.2	Generator Construction	9-3
9.3	Generator Terminology.....	9-4
9.3.1	Generator Frequency	9-4
9.3.2	Mechanical Loading.....	9-4
9.4	Generator Control.....	9-5
9.4.1	Frequency Control.....	9-5
9.4.2	Voltage Control.....	9-5
9.4.3	Generator Rating	9-5
9.5	Excitation and Voltage Regulation.....	9-7
9.5.1	Types of Excitation Systems	9-7
9.5.2	Explanation of Elements of the Excitation System	9-8
9.5.3	Brushless Excitation Systems	9-11
9.5.4	Digital Voltage Regulation	9-11
9.6	Generator Output Breaker	9-12
9.7	Generator Differential Protection	9-13
9.7.1	Generator Monitoring and Protection.....	9-14
9.7.2	Generator Stresses	9-14
9.8	Generator Connection and Alignment to the Engine	9-14
10.0	EMERGENCY DIESEL GENERATOR CONTROL AND MONITORING	10-1
10.1	EDG Control Systems	10-1

TABLE OF CONTENTS

10.2	Engine Protection Systems	10-2
10.3	Engine Parameter Monitoring	10-3
10.3.1	Temperature Monitoring	10-3
10.3.2	Pressure Monitoring	10-4
10.3.3	Engine Overspeed.....	10-4
10.3.4	Vibration Trips	10-5
10.4	Summary of Trips and Alarms	10-5
10.4.1	Shutdown-Trips with Alarms.....	10-5
10.4.2	Alarms-Any Mode-Any Time.....	10-5
10.4.3	Monitored Items.....	10-6
10.5	Typical Engine Control Circuitry	10-6
10.5.1	Starting Circuit.....	10-6
10.5.2	Speed Monitoring and Stop Circuits	10-7
10.5.3	Fault Monitoring Circuits.....	10-8
10.5.4	Summary	10-9
10.5.5	Digital Instrumentation and Control	10-9
10.6	Engine-Generator Responses	10-11
11.0	QUALIFICATION, SITE ACCEPTANCE AND SURVEILLANCE TESTING.....	11-1
11.1	EDG Type Qualification Tests for Nuclear Service	11-1
11.1.1	Three Basic Type Qualification Tests for Nuclear Service EDGs	11-2
11.1.2	Additional EDG Evacuation by Test or Analyses	11-4
11.1.3	Analysis/Test of Design Change to EDG Previously Qualified	11-4
11.2	“Factory” Production Testing	11-4
11.3	Initial On-Site Set-up of EDG.....	11-5
11.4	Site Acceptance Testing.....	11-6
11.5	Pre-Operational EDG Testing.....	11-7
11.6	Periodic Testing (Surveillance).....	11-10
11.6.1	Availability Test.....	11-10
11.6.2	System Operation Tests	11-10
11.7	Records for Each EDG Unit.....	11-10
11.8	Concerns about the Adequacy of Licensee Periodic Testing	11-11
11.9	NRC Position on the Use of EDGs for Peaking	11-11

TABLE OF CONTENTS

11.10	Observation on EDG Control When in Parallel with Grid.....	11-12
11.10.1	Frequency-Load Control Issues When Connected to the Grid.....	11-12
11.10.2	Voltage-KVAR Control Issues When Connected to the Grid.....	11-12
11.11	Typical EDG Surveillance Run	11-14
11.12	Observations Pertaining to EDG Selection and Operation	11-15
12.0	EDG PERFORMANCE MONITORING AND MAINTENANCE	12-1
12.1	EDG Maintenance & the Critical Need for Condition Monitoring	12-2
12.2	Overview of Regulatory Criteria Pertaining to System Requirements.....	12-3
12.3	EDG Parameter Monitoring and Trending Fundamentals.....	12-3
12.4	Monitoring Prerequisites.....	12-4
12.5	Fuel Oil Quality Monitoring	12-5
12.6	Lube Oil Analysis and Trending.....	12-7
12.7	EDG/Support Systems Monitoring.....	12-9
12.8	Jacket and Cooling Water Analysis	12-11
12.9	Exhaust Emissions Analysis	12-11
12.10.	The Use of “Engine Analyzers” to Monitor EDG Performance.....	12-12
12.10.1	Phased Cylinder Pressure Type	12-12
12.10.2	Phased Engine Vibration (VT) and Ultrasonic (UT) Type.....	12-13
12.11	Practical Cylinder Balancing by Approximation Method	12-14
12.12	Crankcase Oil Mist Detection of Engine Mechanical Distress	12-14
12.13	Infra-Red (IR) Scanning - An Effective, Under-Utilized Tool.....	12-14
12.14	Visual (and Other) Human Senses	12-15
12.14.1	The “Walkaround” Inspection.....	12-15
12.14.2	Assembled Inspections	12-16
12.14.2	Disassembled Inspections	12-16
12.15	Selective Maintenance Concerns and Observations for EDGs	12-17

TABLE OF CONTENTS

13.0	EMERGENCY DIESEL GENERATOR CASE STUDIES	13-1
13.1	Starting and Loading Failures.....	13-1
13.2	Controls-Related Failures.....	13-2
13.3	Engine-Mechanical Failures	13-4
13.4	Fire Protection System Issues and EDG Building Fires.....	13-6
13.5	Engine Cooling Failures	13-7
13.6	Fuel Oil/Lube Oil Related Failures.....	13-8
13.7	Special Concerns for Ultra-Low Sulfur Diesel Fuel.....	13-11
13.8	Combustion/Ventilation Air	13-12
13.9	Site Switchyard and Distribution.....	13-13
13.10	Grid Reliability Concerns	13-15
13.11	The Ticking Clock: Aging Issues Relevant to EDG Systems.....	13-16
13.12	Industry EDG Activities.....	13-17
14.0	SOME OTHER ENGINES	14-1
14.1	EMD EDG Engines.....	14-1
14.2	Cooper EDG Engines	14-1
14.3	Nordberg EDG Engines.....	14-2
14.4	Worthington EDG Engines	14-2
14.5	SACM EDG Engines	14-2
14.6	DeLaval EDG Engines.....	14-3
	EDG UNITS AND ASSOCIATED EQUIPMENT AT PLANT SITES	14-22

TABLE OF CONTENTS

APPENDIX A - REFERENCES

APPENDIX B - USNRC REGULATORY GUIDE 1.9, Rev. 4, March 2007

APPENDIX C - IEEE 387-1995

HANDS-ON TRAINING

**SESSION
NUMBER**

0.0 INTRODUCTION TO THE TRAINING SCHOOL

TABLE OF CONTENTS

1.0	THE 2-STROKE CYCLE OP AND 4-STROKE CYCLE ALCO ENGINES	2-49
1.1	OP Engine Rotatable Cutaway Explanation	2-49
1.1.1	Pistons and Piston Rings.....	2-50
1.1.2	Lube Oil Supply to the Piston	2-51
1.1.3	Injection of Fuel into the Cylinder	2-51
1.1.4	Engine Cooling	2-52
1.2	ALCO Engine Cut-away Model Demonstration	2-52
2.0	ENGINE CRANKSHAFT(S)	3-70
2.1	Vibration Damper.....	3-70
2.2	Engine Bearings, Crankshaft End Float and Web Deflection	3-71
2.3	Checking Crankshaft End Float.....	3-73
2.4	Checking the Crank Web Deflection - Crankshaft Alignment	3-73
3.0	PIELSTICK ENGINE.....	3-75
3.1	Cylinder Heads, Valves & Valve Operating Mechanism	3-75
3.2	Cylinder Liner-Jacket Assembly	3-76
3.3	Main Bearing Assembly.....	3-77
3.4	Piston and Connecting Rod Assembly	3-78
3.5	Power Output Shaft Gear-Drive Support Systems.....	3-78
4.0	ENGINE CRANK-LEAD & FUEL INJECTION TIMING (OP ENGINE).....	3-80
4.1	Checking/Setting the Crank-lead	3-80
4.2	Checking High Point of CAM	3-82
4.3	Setting the Injection Pump Timing	3-83

TABLE OF CONTENTS

HANDS ON TRAINING

**SESSION
NUMBER**

5.0	COMBUSTION AIR TURBOCHARGERS & SCAVENGING BLOWERS	4-46
5.1	Turbochargers	4-46
5.2	Scavenging Air Blowers.....	4-48
6.0	FUEL INJECTION PUMPS & FUEL INJECTION NOZZLES	4-49
6.1	Injection Pumps and Injection Nozzles	4-49
6.2	Injection Nozzle Assemblies	4-49
7.0	ENGINE LUBRICATION SYSTEM	5-26
7.1	Lube Oil Flow Path	5-26
7.2	Components	5-26
8.0	ENGINE COOLING SYSTEMS	6-11
8.1	Jacket Water Cooling System.....	6-11
8.2	Components	6-11
9.0	DIRECT AIR INJECTION SYSTEM.....	7-27
9.1	Air Start System and its Components	7-27
9.1.1	Air Start Distributor	7-27
10.0	GENERATOR, EXCITER, & VOLTAGE REGULATION	9-34
10.1	The Generator	9-34

TABLE OF CONTENTS

1-1	Diesel Generator Systems	1-12
2-1	Fixed Volume	2-16
2-2	Fixed Volume Plus Heat	2-16
2-3	Addition of Piston	2-17
2-4	Addition of Piston Plus Heat	2-17
2-5	Addition of Crankshaft.....	2-18
2-6	Addition of Crankshaft Plus Heat	2-18
2-7	Cylinder Configuration - 4-Stroke Cycle.....	2-19
2-8	Intake of Air Charge	2-19
2-9	Compression of Air Charge.....	2-20
2-10	Injection of Fuel	2-20
2-11	Development of Power.....	2-21
2-12	Exhaust of Spent Gases	2-21
2-13	Air Standard Diesel Cycle	2-22
2-14	Diesel Cycle - Pressure vs Stroke Diagram.....	2-23
2-15	Cylinder Configuration - 2-Stroke Cycle EMD Engine.....	2-24
2-16	Intake Event.....	2-25
2-17	Compression Event.....	2-26
2-18	Combustion and Power.....	2-27
2-19	Cylinder Configuration - 2-Stroke Cycle, OP Engine.....	2-28
2-20	Intake Event.....	2-29
2-21	Compression Event.....	2-29
2-22	Combustion and Power Event	2-29
2-23	Cylinder Bore and Stroke.....	2-30
2-24	Clearance Volume	2-31
2-25	Compression Ratio	2-32
2-26	Typical Times for Events 900 rpm Diesel Engines.....	2-33
2-27A	Typical Timing Diagram - 4-Stroke Cycle.....	2-34
2-27B	Typical Timing Diagram - 2-Stroke Cycle.....	2-35
2-28	Cross Section of Fairbanks Morse OP Engine.....	2-36
2-29	Cross Section of ALCO 4-Stroke Cycle Engine	2-37
2-30	OP Engine Crankshaft	2-38
2-31	OP Engine Vertical Drive.	2-39
2-32	Cylinder Liner and Associated Parts.....	2-40
2-33	Piston and Connecting Rod Disassembled.....	2-41
2-34	Operation in Single Cylinder	2-42
2-35	Injection Nozzle Mounting-OP Engine	2-43
2-36	Injection Pump Adjustments	2-44
2-37	Chain Type Camshaft Drive Mechanism.....	2-45
2-38	Camshaft Control End	2-46
2-39	Fuel Injection Assembly	2-47
2-40	Injection Pump Plunger Positions	2-48
3-1	Cylinder Forces.....	3-11
3-1A	Cylinder X-Y Forces during Power Stroke	3-12
3-2	Multi-Piece Construction	3-13

TABLE OF CONTENTS

3-3	12-Cylinder OP Engine Cylinder Block	3-14
3-4	16-Cylinder PC Engine Cylinder Block.....	3-15
3-5	Dry Type Cylinder Liner	3-16
3-6	Wet Type Cylinder Liner	3-17
3-7	Integral Type Cylinder Liner.....	3-18
3-8	OP Engine Main Bearings.....	3-19
3-9	OP Piston and Con-Rod Assembly	3-20
3-10	Trunk Type Piston.....	3-21
3-11	Floating Skirt Piston	3-22
3-12	Piston Ring Nomenclature	3-23
3-13	Piston Ring Sealing.....	3-24
3-14	Compression Ring Designs	3-25
3-15	Piston Ring Joint Design.....	3-26
3-16	Oil Control Ring	3-27
3-17	Oil Control Ring Designs.....	3-28
3-18	Piston Ring Placement.....	3-29
3-19	Two-piece Crown Piston with Connecting Rod & Wrist Pin	3-30
3-20	Conventional Connection Rod	3-31
3-21	Angle Cut Connection Rod	3-31
3-22	Articulating Connecting Rod Assembly	3-32
3-23	Fork and Blade Connecting Rod Design (EMD)	3-33
3-24	OP Engine Crankshafts	3-34
3-25	Engine Crankshaft Oil Passages	3-35
3-26	Engine Flywheel	3-36
3-27	Spring Type Vibration Damper.....	3-37
3-28	Gear Type Viscous Damper.....	3-38
3-29	Bifilar Type Vibration Damper	3-39
3-30	Cylinder Head Assembly.....	3-40
3-31	Valve Seat Angles.....	3-41
3-32	Valve Seat Assembly	3-41
3-33	Camshaft Lobes.....	3-42
3-34	Cam Follower Designs	3-43
3-35	Gear Type Camshaft Drive Mechanism	3-44
3-36	Chain Type Camshaft Drive Mechanism-OP	3-45
3-37	Rocker Arms and Pushrods	3-46
3-38	Pendulum Torsional Damper	3-47
3-39	Monofilar Type Torsional Damper	3-48
3-40	Crankshaft Strain Gauge Readings	3-49
3-41	Crankshaft Strain Readings	3-50
3-42	Pielstick Engine Cross Section	3-51
3-43	Cylinder Head with Rocker Arm Assembly	3-52
3-44	Rocker Arm Assembly. . ..	3-53
3-45	Sequence and Timing Events .. .	3-54
3-46	Standard Main Bearing . ..	3-55
3-47	Lube Oil Distribution . ..	3-56
3-48	Timing Gear and Auxiliary Drives	3-57

TABLE OF CONTENTS

3-49	Camshaft Bearing Lubrication.....	3-58
3-50	Fuel Injection Pump	3-59
3-51	Flexible Drive Gear	3-60
3-52	Overspeed Governor and Trip Mechanism	3-61
3-53	Manual Barring Device	3-62
3-54	Crank-lead Timing Drive End	3-63
3-55	Crank-lead Timing	3-64
3-56	OP Engine Drive Gear and Timing Chain.	3-65
3-57	Flywheel Coupling Readings	3-66
3-58	OP Engine Fuel Injection Pump.....	3-67
3-59	Depth Micrometer	3-68
3-60	Fuel Control Linkage Adjustment	3-69
4-1	Combustion Activity	4-17
4-2	Diesel Cycle - Pressure vs Stroke.....	4-18
4-3	Basic Intake and Exhaust System	4-19
4-4	Dry Type Air Filter.....	4-20
4-5	Oil Bath Air Filter.....	4-21
4-6	Blower/Supercharger	4-22
4-7	Exhaust Driven Turbocharger	4-23
4-8	Intake Air and Exhaust Flow	4-24
4-9	Typical Basis for Diesel Generator Ratings/DEMA Ratings	4-25
4-10	Exhaust Gas Silencer	4-26
4-11	Fuel Oil Storage and Transfer System.....	4-27
4-12	Fuel Oil Supply System.....	4-28
4-13	Fuel Oil Strainer.....	4-29
4-14	Fuel Oil Supply Pump	4-30
4-15	Fuel Oil Filter	4-30
4-16	Pump and Nozzle System.....	4-31
4-17	OP Injection Pump Construction	4-32
4-18	Zero Fuel Delivery.....	4-33
4-19	Low Power	4-34
4-20	Full Power.....	4-34
4-21	Injection Nozzle	4-35
4-22	Injection Nozzle Spray Pattern.....	4-36
4-23	Pintle Nozzle	4-37
4-24	Unit Type Fuel Injector	4-38
4-25	Injector Operation.	4-39
4-26	Zero Fuel Delivery.....	4-40
4-27	Low Power	4-41
4-28	Full Power.....	4-42
4-29	Turbocharger Cutaway Section	4-43
4-30	Casing Assemblies	4-44
4-31	Brown and Boveri Turbocharger	4-45
5-1	Frictional Surfaces	5-10
5-2	Types of Friction	5-11

TABLE OF CONTENTS

5-3	Rolling Friction	5-12
5-4	Laminar Flow	5-13
5-5	Wedge Formation	5-14
5-6	Shaft and Bearing	5-15
5-7	Lube Oil Circulating and Cooling System.....	5-16
5-8	Lubricating Oil Pump.....	5-17
5-9	Lubricating Oil Filters	5-17
5-10	Lubricating Oil Cooler	5-18
5-11	Pressure Relief Valve	5-19
5-12	Pressure Regulating Valve	5-20
5-13	Lube Oil System with Keepwarm Added.....	5-21
5-14	Pielstick Lube Oil Flow.....	5-22
5-15	Pielstick Valve Rocker Flow.....	5-23
5-16	Crankcase Diaphragm Type Pressure Monitoring Switch.....	5-24
5-17	Bearing Temperature Probe	5-25
6-1	Jacket Water Cooling System with Keepwarm	6-7
6-2	Jacket Water Pump.....	6-8
6-3	Thermostatic Control Valve.....	6-9
6-4	Intercooler Water Cooling System	6-10
7-1	Cranking Speed versus Compression Pressure	7-13
7-2	Starting Air System	7-14
7-3	Starting Air Admission Valve.....	7-15
7-4	Starting Air Distributor (OP Engine).....	7-16
7-5	Spool Valve - Off Cam	7-17
7-6	Spool Valve - High Cam.....	7-17
7-7	Spool Valve - Low Cam	7-17
7-8	Starting Air Check Valve-Open	7-18
7-9	Starting Air Check Valve-Closed.....	7-18
7-10	Vane Type Starting Air Motor.....	7-19
7-11	Bendix Drive Assembly	7-20
7-12	Governor Boost Cylinder (Woodward Governor)	7-21
7-13	Starting Air Supply System	7-22
7-14	Typical Components Direct Air-Over-Piston Starting System	7-23
7-15	Typical Direct Air-Over-Piston Starting System	7-24
7-16	Electric Starting Motor System.....	7-25
7-17	Air Start Check Valve.	7-26
8-1	Droop-Isochronous Relationship.....	8-22
8-2	Basic Mechanical Governor	8-23
8-3	Basic Governor with Hydraulic Power Piston	8-24
8-4	Electronic Governor Hydraulic Actuator	8-25
8-5	EGB 10C Actuator Schematic.....	8-26
8-6	EGA Governor Control Box	8-27
8-7	2310A Control Box.....	8-28
8-8	EGA Governor Control Block Diagram.....	8-29

TABLE OF CONTENTS

8-9	2301A Control View	8-30
8-10	2301A Control Block Diagram.....	8-31
8-11	Typical Magnetic Pickup	8-32
8-12	MOP for 125 VDG Motor.....	8-33
8-13	Schematic of MOP Unit.....	8-34
8-14	Digit Reference Unit (DRU).....	8-35
8-15	DRU Connections	8-36
8-16	Relationship Between Governor Output and Control (Rack).....	8-37
8-17	Over-Speed Trip (Governor) Mechanism.....	8-38
9-1	Conductor in Magnetic Field	9-16
9-2	Simple Generator (Alternating Current)	9-17
9-3	Single Phase Sine Wave	9-18
9-4	Three Phase Generation.....	9-19
9-5	Cutaway of Generator - Identification of Parts	9-20
9-6	OP Engine Generator Assembly (under test).....	9-21
9-7	Cut-away of Generator - Identification of Parts	9-22
9-8	Complete Rotor Assembly	9-22
9-9	Generator Shaft - Coupling End View	9-23
9-10	Rotor Spider.....	9-23
9-11	Field Pole Wedges.....	9-24
9-12	Field Pole Blocking	9-24
9-13	Field Pole with Amortiser Bars	9-25
9-14	Field Wiring to Slip Rings	9-25
9-15	Slip Ring Assembly	9-26
9-16	Winding Coil Form	9-26
9-17	Windings Installed in Stator Slots	9-27
9-18	Coil Tying and Bracing	9-27
9-19	Lead Cable Terminations	9-28
9-20	Complete Stator Assembly	9-28
9-21	Rotor Installed within Stator	9-29
9-22	Bearing and Housing Assembled to Rotor Shaft.....	9-29
9-23	Exciter System Block Diagram (SEVR/SB Types)	9-30
9-24	Brushless Exciter System Diagram.....	9-31
9-25	Generator Differential Fault.....	9-32
9-26	Engine-Generator Alignment	9-33
10-1	Starting Circuitry	10-14
10-2	Speed Monitoring and Stop Circuitry	10-15
10-3	Fault Shutdown and Monitoring Circuits	10-16
10-4	Motor Start Loading	10-17
10-5	Typical Loading Situation.....	10-18
11-1	IEEE 387-1995 Table 3, Site Testing of EDGs	11-21
11-2	IEEE 387-1995 Table 4, Test Parameters (Required Data).....	11-22
12-1	Piston with Advanced Tin Smear	12-20

TABLE OF CONTENTS

12-2	Failed Piston - Tin Wiped Off	12-21
12-3	EDG Diagnostic Report - PFP vs Crank Angle (Right Bank)	12-22
12-4	EDG Diagnostic Report - PFP vs Crank Angle (16cyl.).....	12-23
12-5	EDG Diagnostic Report - PFP vs Crank Angle & Swept Volume (4L)	12-24
12-6	EDG Diagnostic Report - PFP vs Crank Angle & Swept Volume (2R).....	12-25
12-7	Crankcase Oil Mist Monitoring System	12-26
12-8	EDG Failure by Responsible System.....	12-27
12-9	IR Thermographs of Impending Failures.....	12-28
14-1	EMD Engine Cross Section	14-4
14-2	EMD Engine Service Data Sheet.....	14-5
14-3	Cooper Engine Connecting Rods & Bearings	14-6
14-4	Cooper Engine Service Data Sheet.....	14-7
14-5	Cooper Engine Cross Section.....	14-8
14-6	Cooper Engine Cross Section (left side).....	14-9
14-7	Cooper Engine Timing Bar Graph.....	14-10
14-8	Nordberg Engine Linkshaft	14-11
14-9	Nordberg Engine Service Data Sheet.....	14-12
14-10	Nordberg Engine Operating Pressures & Temperatures	14-13
14-11	Nordberg Engine Cross Section	14-14
14-12	Worthington Engine Service Data Sheet.....	14-15
14-13	Worthington Engine Cross Section	14-16
14-14	Worthing Engine Timing Diagram	14-17
14-15	SACM Engine Service Data Sheet.....	14-18
14-16	SACM Generator Service Data Sheet.....	14-19
14-17	DeLaval Engine Service Data Sheet.....	14-20
14-18	DeLaval Engine Articulating Connecting Rod Assembly.....	14-21
	EDG UNITS AND ASSOCIATED EQUIPMENT AT PLANT SITES	14-22